

Work Order ID 87755

87755

Page 1

July-11-12 11:26:45 AM

Item ID: D3825-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Rib Assembly (Basket End)

Stop ***NS2***

Start Date: 11/07/2012 Start Qty: 6.00

~~*6*~~ 8
~~*6*~~

Cust Item ID:

Required Date: 17/07/2012 Req'd Qty: 6.00

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/07/11*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3825

Rev *A*

B per ECN 12-603

100

0.00

100

Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3825-1 rib as per dwg D3825

2- drill hole (3/16") in D3825-1 using DT9438 jig and open to finish size as per dwg D3825

3- c'sink hole as per dwg

4- remove identification markings

5- deburr

and D4021-9 bushings

6- weld D2327-3 spacer bushing and D3759-1 bushing as per dwg D3825

A/R S.S. Rod Batch: *122130*

7- grind bushing weld flush where indicated on dwg D3825

8- deburr if necessary

8A *6/12.8.28*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87755

87755

Page 2

July-11-12 11:26:45 AM

Item ID: D3825-041

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Rib Assembly (Basket End)

Start Date: 11/07/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 17/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Memo

0.00

Quality Control

8

8

12-08-28

DAS
18
8-83

140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.00

Quality Control

DAS
16
9-83

12/08/28

8

150

Identify as per dwg & Stock Location: W A

0.00

150

Packaging

Memo

0.00

Packaging

8

12-8-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 87755

July-11-12 11:26:45 AM

87755

Page 3

Item ID: D3825-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Rib Assembly (Basket End)

Start Date: 11/07/2012 Start Qty: 6.00

6

Cust Item ID:

Required Date: 17/07/2012 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

ML5 12108130

12-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-11-12 11:26:50 AM

Page 1

Work Order ID: 87755

87755

Parent Item: D3825-041

D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 11/07/2012

Required Date: 17/07/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2327-3		Manufactured	No			100	Each	26.0000	1	26			

D2327-3

Spacer Bushing

**

PD 12-08-24

Location	Loc Qty	Loc Code
WA	22	
82325	22	
WA005	4	
75564	1	
77229	1	
81144	2	

B88889 → ①

①

D3759-1

Manufactured No

100 Each

170.0000

D3759-1

Bushing

** 1

26

120718 PD 12-08-24

Location	Loc Qty	Loc Code
WA	163	
79213	1	
83464	162	
WA005	7	
66489	1	
82785	6	

B86550 → 3

PTO

D4021-9 →

B88377 → ①①

PD 12-08-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12.07.16		QTY(1) D3759-1 BushWn + QTY(4) D4021-9 BushWn REQ'D. PERMANENT CHG. D4021-9 B/W:				12.07.16	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

July-11-12 11:26:50 AM

Page 2

Work Order ID: 87755

87755

Parent Item: D3825-041

D3825-041

Parent Item Name: Rib Assembly (Basket End)

Start Date: 11/07/2012

Required Date: 17/07/2012

Start Qty: 6.00

Required Qty: 6.00

M304TS0.750W.065

Purchased

No

100

f

1,293.116

2.125

13.42105

M304TS0 750W 065

**

304 SQ Tube .75x.75x.065W

PC 12.8.24

Location

Loc Qty

Loc Code

MAT

1000

~~MAT22425~~

112398

0

122051

1000

MAT017

252.1169370

120267

26.9468670

120633

225.17007

13.42105

MAT018

41

7636

41

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

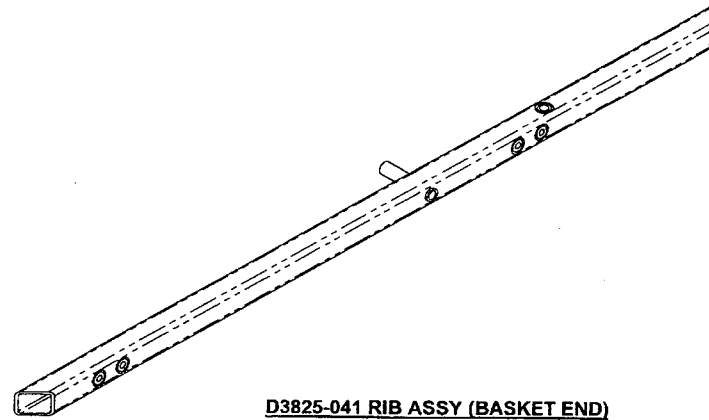
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

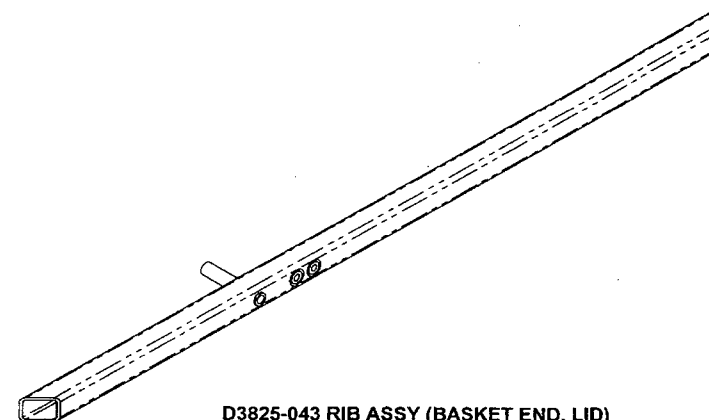
8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	P/N	DESCRIPTION
	X		D3825-041	RIB ASSEMBLY (BASKET END)
		X	D3825-043	RIB ASSEMBLY (BASKET END, LID)
1		1	D2327-1	SPACER BUSHING
2	1		D2327-3	SPACER BUSHING
3	1		D3759-1	BUSHING
4	1		D3825-1	RIB
5		1	D3825-3	RIB
6	4	2	D4021-9	BUSHING

△



D3825-041 RIB ASSY (BASKET END)



D3825-043 RIB ASSY (BASKET END, LID)

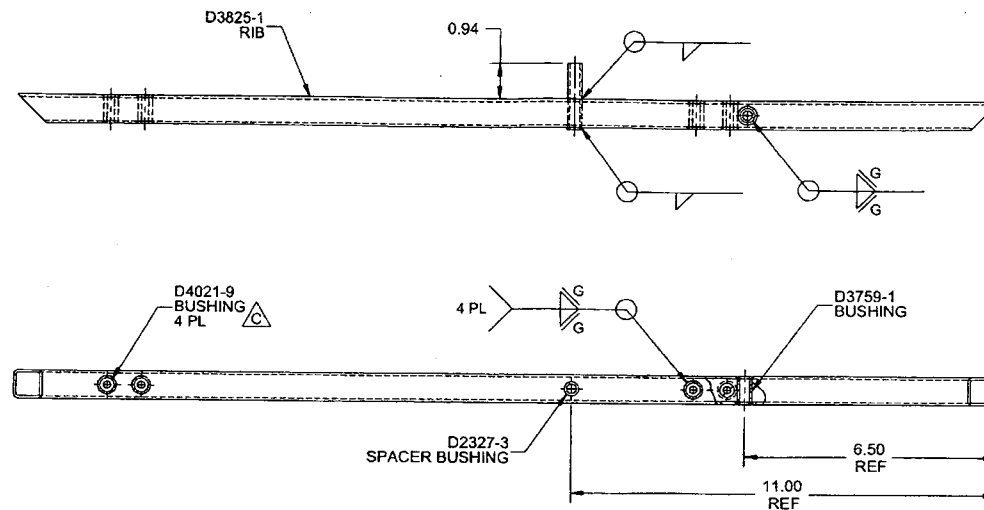
RELEASED
2012-08-03

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: D3825-041 = 1.27 lbs; D3825-043 = 1.23 lbs
 - 8) WELDING: PER DART QSI 004

C	QTY(4) D4021-9 ON -041 AND QTY(2) D4021-9 ON -043 WERE D3759-1. CORRECTED DIM (ZN B3-4) WAS 14.875. REASON FOR CHG: AN3 SIZE BOLTS REQ'D IN THOSE LOCATIONS.	MB	12.07.18
B	QTY(5) FOR D3759-1 WAS QTY(1): AFFECTS D3825-041/-1 (ZNS D3-1, C4-2, C3-2, D4-4, C6-4, C4-4, C3-4). ADDED D3825-043/-3. REASON: PART 10-50.	MB	12.05.11
A	NEW ISSUE	MB	08.09.23
REV.	DESCRIPTION	BY	DATE
DESIGN	1		
DRAWN	1		
CHECKED	AP		
MFG. APPR.	1		
APPROVED	1		
DE APPR.	1		
DATE	12.07.18		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3825	REV. C
TITLE RIB ASSY (BASKET END)	SCALE NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRINTED AND CONSIDERED TO BE SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

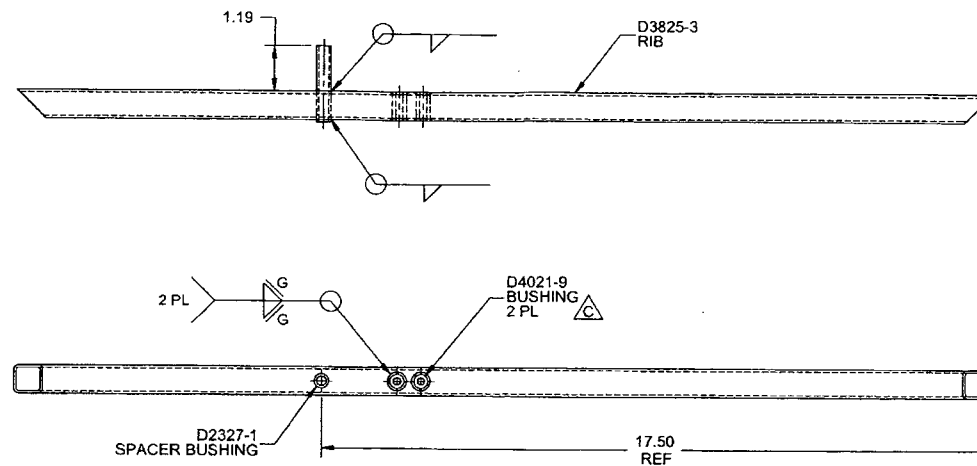
8 7 6 5 4 3 2 1



D3825-041 RIB ASSY (BASKET END)

RELEASED
2012-08-03
JND

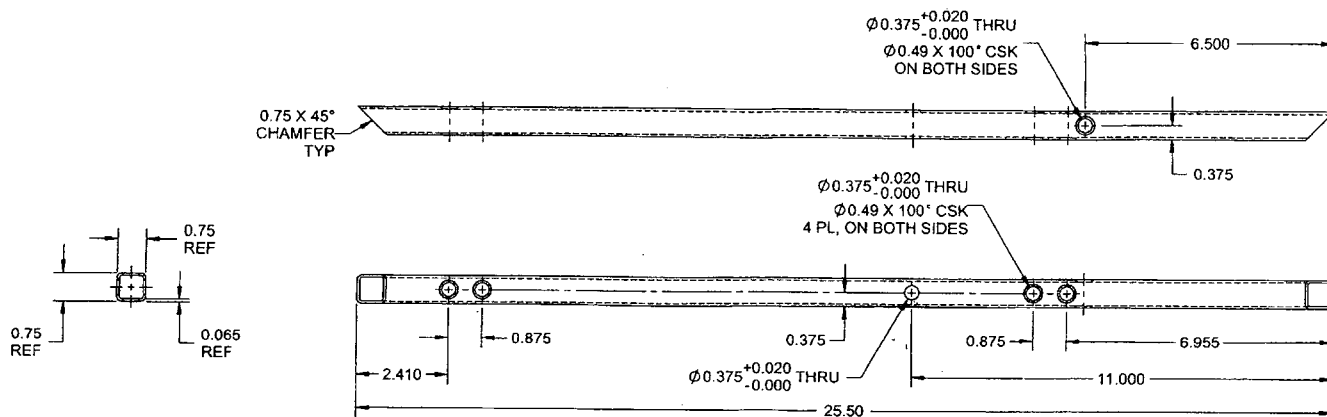
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	AB	DRAWING NO.	REV. C
MFG. APPR.		D3825	SHEET 2 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	
DATE	12.07.18	NTS	
<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>			



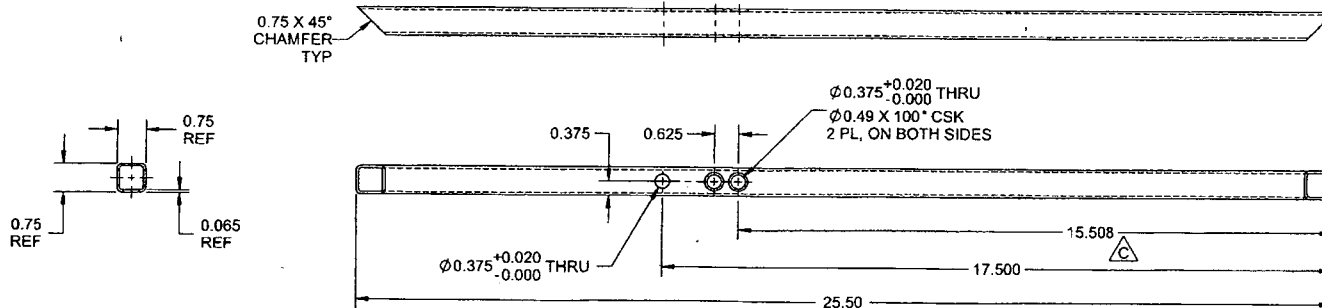
D3825-043 RIB ASSY (BASKET END, LID)

RELEASED
2012-08-03
WHP

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3825	REV. C
MFG. APPR.		SHEET 3 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	12.07.18	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	



D3825-1 RIB



D3825-3 RIB

RELEASED
2012-08-03

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.16 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3825	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET END)	NTS
DATE	12.07.18	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESSED UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			